

Work Order ID 72855

Tuesday, August 16, 2011 1:29:32 PM



Page 1

Item ID: DSK080

Accept



Setup Start



Revision ID:

Stop



Item Name: D2896-1 TURNING DETAIL

Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 11-08-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK080	Rev A								

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA167

SA 11/9/12

10 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/9/12

10 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72855

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Page 2

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Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: MAT 050

SL-11-09-14

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/9/14

MF 11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 16, 2011 1:29:40 PM

Page 1

Work Order ID: 72855



Parent Item: DSK080

Parent Item Name: D2896-1 TURNING DETAIL


Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011  17-4 SS Roundbar 6.50"OD		Manufactured	No				Each	0.0000		10			



SA 11/9/12

B 72808

X 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	72855
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.485	3.485	3.485	3.485	3.485
B	3.990	4.010		3.998	4.001	4.007	4.001	4.000
C	3.825	3.845		3.838	3.835	3.835	3.835	3.835
D	0.718	0.738		.728	.725	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	3.705	3.725		3.716	3.715	3.715	3.715	3.715
G	1.360	1.380		1.372	1.372	1.372	1.371	1.371
H	1.250	1.260		1.255	1.256	1.256	1.258	1.258
I	6.490	6.510		6.500	6.500	6.500	6.500	6.500
J	0.022	0.042		R.031	R.031	R.031	R.031	R.031
K	0.240	0.260		.260	.260	.260	.260	.260
L	0.107	0.127		.115	.114	.113	.113	.113
M								
N								
O								
P								

Measured by:  Date: 11/9/12

Audited by:  Date: 11-09-14

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

DART AEROSPACE LTD		Work Order:	
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.485	3.485	3.485	3.485	3.485
B	3.990	4.010		4.000	3.999	3.998	4.000	4.000
C	3.825	3.845		3.835	3.835	3.838	3.837	3.837
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	3.705	3.725		3.715	3.716	3.717	3.716	3.717
G	1.360	1.380		1.371	1.371	1.371	1.371	1.371
H	1.250	1.260		1.256	1.257	1.257	1.256	1.257
I	6.490	6.510		6.500	6.498	6.499	6.500	6.500
J	0.022	0.042		R.031	R.031	R.031	R.031	R.031
K	0.240	0.260		.260	.260	.260	.260	.260
L	0.107	0.127		.116	.115	.117	.115	.115
M								
N								
O								
P								

Measured by: SA Date: 11/9/12

Audited by: JL Date: 11-09-14

Prototype Approval: _____ Date: _____

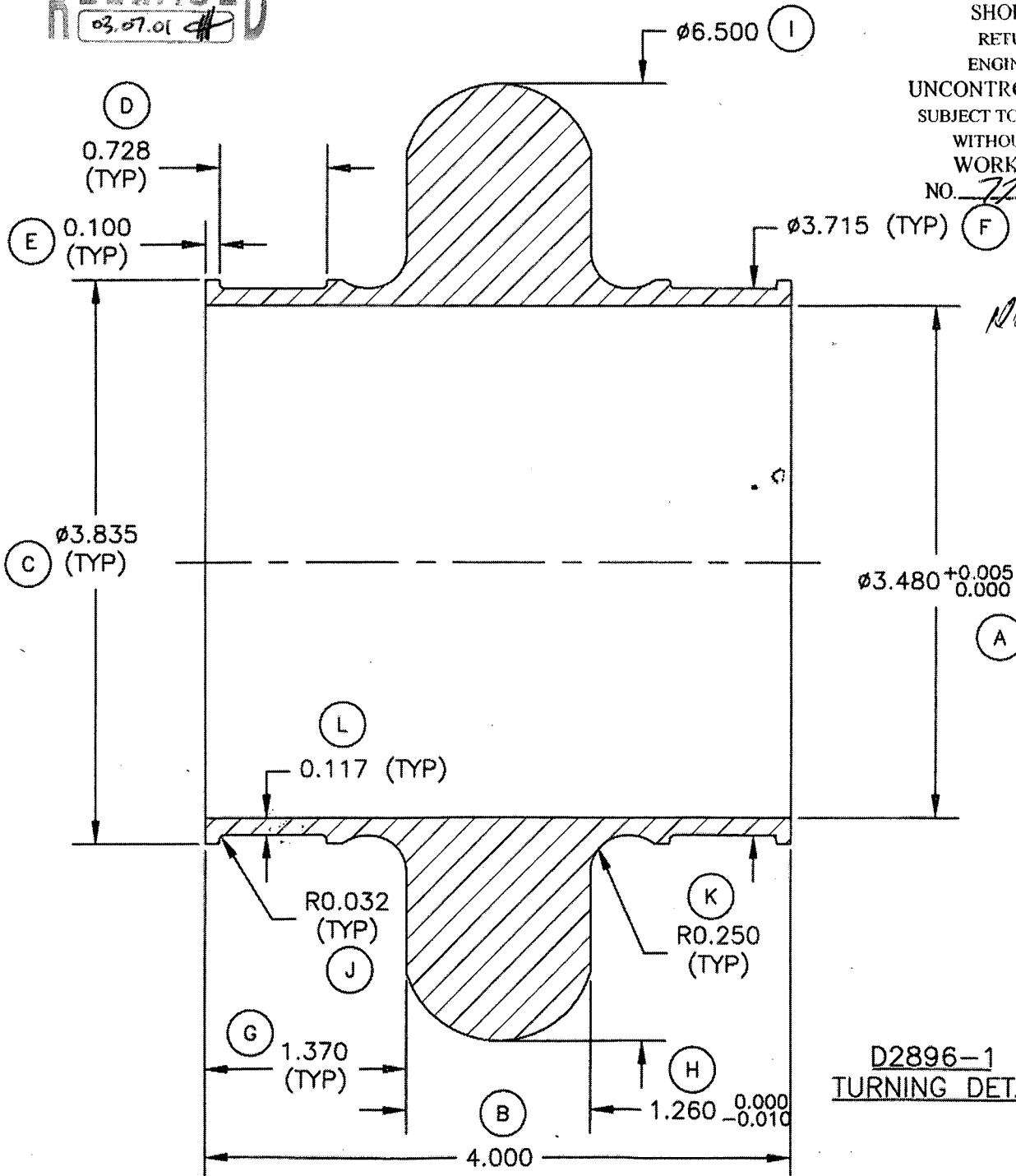
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SA</u>



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72855



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